

METHOD OF DIE CASTING SPHEROIDAL GRAPHITE CAST IRON

ABSTRACT OF THE DISCLOSURE

A method of die casting spheroidal graphite cast iron able to prevent formation of chill crystals to allow the crystallization of fine spheroidal graphite and simultaneously prevent the formation of internal defects, including the steps of preparing a die formed with a heat insulation layer at inside walls of a cavity, filling molten metal having a composition of the spheroidal graphite cast iron through a runner into the cavity, closing the runner so as to seal the cavity right before the molten metal in the cavity starts to solidify, and allowing the molten metal to solidify by the action of the inside pressure caused by crystallization of the spheroidal graphite in the sealed cavity.